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D5549-012
Job Sheet 183901



Part No: D5549-012

Job Qty: 1 ea

Part Name: Fwd Beam Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5549 REV.B IPP REV:A 18.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

006238

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/12/18	0.00	0.00	Start Up Small Fab-4	80%	11/1/18
110	Small Fab	1 pcs		10/12/18	0.00	0.67	Small Fab-9	80%	DAS
120	QC	1 pcs		10/12/18	0.00	0.00	QC5		DAS 35
130	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging3-2		21
140	QC21-SA	1 Ea		10/12/18	0.00	0.00	QC21		3-55 NOV 13 2018

Part Op 110 - 1- Install and Manufacture D2690-13 lanyard. 2- Install D5553-1 and D5554-3 with bolts and quick pin to Aft Beam. Descriptions: Torque nut as per dwg. (see note 8) 3- Install D5550-041 to Aft Beam. Torque nut as per dwg. (see note 9)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-26A	Bolt	8 Ea (8 ea)	90-Start up Operation	5041128
AN4-27A	Bolt	2 Ea (2 ea)	90-Start up Operation	5019361X3
CBL-1240	Cable	2.8000 ft (2.8 ea)	90-Start up Operation	5032661
CBL-460	Loop Sleeve	4 Ea (4 ea)	90-Start up Operation	5092216 3x S1193
D5549-1	Fwd Beam	1 Ea (1 ea)	90-Start up Operation	5125188
D5550-041	Fwd Outboard Beam Assembly	1 Ea (1 ea)	90-Start up Operation	5124943
D5553-1	Bracket	2 Ea (2 ea)	90-Start up Operation	5060041X1
D5554-3	Bracket	1 Ea (1 ea)	90-Start up Operation	5036043
MS17984-C625	Pin, Quick Release	2 Ea (2 ea)	90-Start up Operation	5013852
MS20002C6	Washer	6 Ea (6 ea)	90-Start up Operation	5089343
MS21042L4	Nut	10 Ea (10 ea)	90-Start up Operation	5094593
MS21042L6	Nut	6 Ea (6 ea)	90-Start up Operation	5083542
MS21250-06026	Bolt	6 Ea (6 ea)	90-Start up Operation	5013852
NAS1149D0463J	Washer	20 Ea (20 ea)	90-Start up Operation	5092780
NAS1149D0663J	Washer	6 Ea (6 ea)	90-Start up Operation	5093765

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-26A	8	40	0
	AN4-27A	2	28	0
	CBL-1240	3	387	0
	CBL-460	4	379	0
	D5549-1	1	0	0

D5550-041	1	0	0
D5553-1	2	3	0
D5554-3	1	5	0
MS17984-C625	2	8	0
MS20002C6	6	105	0
MS21042L4	10	4,255	0
MS21042L6	6	410	0
MS21250-06026	6	13	0
NAS1149D0463J	20	6,258	0
NAS1149D0663J	6	1,246	0

Part Specifications

Specifications could not be found.

Chris Provencal

From: Chris Provencal
Sent: Monday, November 12, 2018 4:50 PM
To: 'David Shepherd'
Subject: NCR D5549-011 (D117-1044 Basket)
Attachments: NCR-D5549-041.jpg; IIN.jpg

David,

RE: D5549-011 Fwd Beam Assembly

The qty(1) pip pin hole in the D5549-1 Fwd Beam was misaligned with the D5553-1 Bracket that together captures the D5069 a/c attachment adapter (ref attached IIN.jpg). The misalignment was side-to-side and was enough to just prevent the pip pin from passing.

The $\varnothing 0.377+0.002/-0.000$ hole was opened with a $\varnothing 0.386$ reamer in the D5549-1 Fwd Beam (only) allowing the pip pin to pass thru. $\varnothing 0.386$ is the standard for a "close" fit for a 3/8" bolt.

The hole in the D5553-1 Bracket is unchanged, which is what captures the pip pin. Even if the pip pin were to be installed backwards, the $\varnothing 0.386$ hole doesn't allow the 0.440 wide pins to pass through without pushing the pip pin button. When assembled with the D5069-1 Adapter (attached photo), there is enough play in the entire system that the pip pin bears on all surfaces under load.

Would you agree that this is acceptable?

Sincerely,

Chris Provencal, P.Eng
Senior Engineer

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Entered:

Date:

LR Nov 19/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

19-7742

Route update only ☐

Job:

183901

Part No.

DSS49-012

DISPOSITION

Rework ☒Scrap ☐Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐Machining ☐Large Fab ☐Cross tube ☐Small Fab ☒Finishing ☐Eng. (Non-AW) ☐Prod. Eng. Coord. ☐Rec/Store/Packaging ☐Engineering ☐Water Jet ☐Supplier ☐Quality ☐

Date :

19-05-11

Sequence #:

110

QTY Affected :

①

MRB (QSI042)

 MSP 12 18/11/13
 10/11/13

Description Work Order Deviation

Disposition

Completed By

 10/11/13
 Lead hand / Supervisor

PD 19-05-11

QC / QA Coordinator

PD 19-05-11

$\phi 0.377^{+0.002}_{-0.000}$ hole on one side was opened
 to $\phi 0.386$ to allow pip pin to install.
 Hole in DSS49-1 was misaligned side-to-side
 and didn't allow pip pin to install.

Acceptable per attached email.

Root Cause

Operator ☒Manufacturing Process ☐Equip/Tooling ☐Handling/Preservation ☐Material ☐Product Improvement ☐Process Improvement ☐Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced☐ Bending☐ Crushing☐ Cracks☐ Crimp/Kink/Ripple/Wave/Twist☐ Marks/Chatter☐ Mislabeled☐ Contamination☐ Misaligned/off center☐ BOM/Route☐ Broken/Damage/Defect☐ Incomplete/Unclear Instructions☐ Drill Holes☒ Fit/Function☐ Power Loss/Surge☐ Folio/Program☐ Grain Direction☐ Weld☐ Wrong Stock Pulled☐ Out of Sequence☐ Off-set/Set-up☐ Positioned Wrong☐ Outside Tolerance☐ Drawing☐ Finish☐ Part Lost/Missing☐ Misread

Other/Details: